

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014919**Date Inspected:** 18-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

8CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 046 located at SEG047B counter weight side segment. Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR1631 procedure.

Shield Metal Arc Welding (SMAW) VT repair welding was performed various locations on the T Stiffener and I rib hold back welds. Welder is identified as Mr. Ni Leijiang (037723). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 169 located at SSD18-PP070 cross

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beam side segment. Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 046 located at SEG048B cross beam side segment. Welder is identified as Mr. Qie Jianzhou (067571). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and CWR 1618 (R3) procedure.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 169 located at SSD22-PP070 cross beam side segment. Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

8 East/ 8 West/ 7 East

1. Sea fasteners and cable trays are being installed at various locations inside segment.

7 West

1. Grit blasting at various locations (internal/ external) on segment.

7DE

1. Heat straightening was performed on damaged FL3 at panel point 58 located on the cross beam side of segment per HSR (B)-373.

9CE

1. Beveling of deck plate weld splice at panel point PP76 utilizing a mechanical guided torch.

8BW/8CW

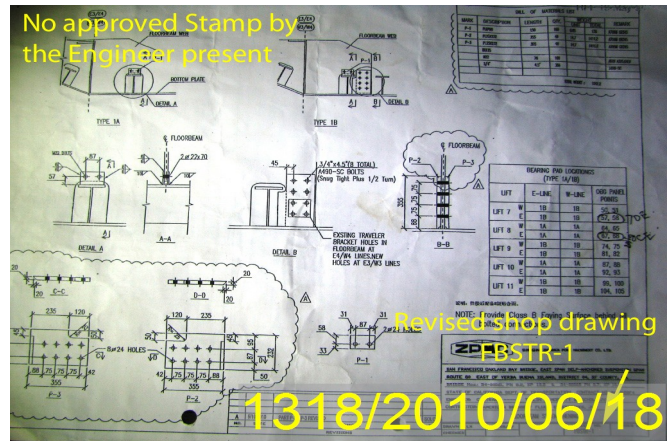
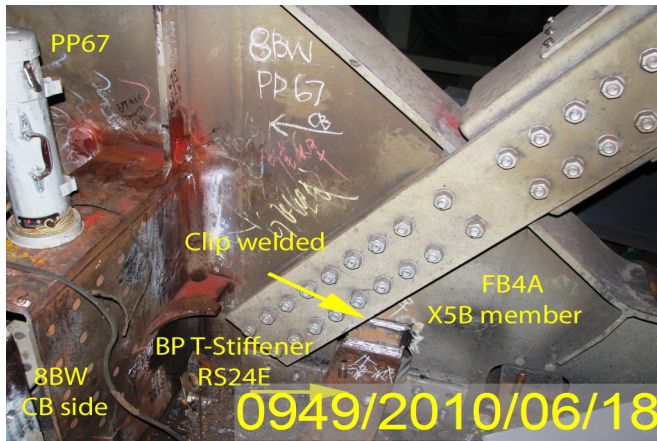
During random in-process visual inspection at Segments 8BW/8CW, this QA Inspector observed welding of clip plate to the FBs and bottom plate (BP) T-Stiffeners at various panel points (PP) locations. This QA Inspector noted work was being performed without the approved shop drawing. RFI ZPMC/QP703-R07 and revised drawing sheet # FBSTR-1 was present at the time. The Engineer was not aware of the RFI or the revised shop drawing being used.

This QA Inspector issued an incident report for noted issue for today's work shift.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By: Alaniz, Joe

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer